

Work Order ID 136061

Thursday, August 27, 2015 2:29:32 PM

136061

Page 1

Item ID: D3580-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Joggle Bracket
Start Date: 8/27/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/27/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MJS Date: AUG 27 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3580	C

100 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D3580-1F as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

(20)

08/15/09/08

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(20)

08/15/09/08

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

(20)

DAS
38
9-89
SEP 09 2015

Work Order ID 136061

Thursday, August 27, 2015 2:29:32 PM

136061

Page 2

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Required Date: 8/27/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					DAS 30 9-89	70		SEP 09 2015
Small Fab	Memo	0.00							
Small Fab	Bend as per dwg D3580 using 1/8" offset die								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
QC	Memo	0.00					(20)		SEP 10 2015
Quality Control									
145		0.00							
145	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							DAS 34 9-89
Powder Coating	START TIME: 10:55. OVEN TEMPERATURE: 320° FINISH TIME: 11:25						20 φ.		

Work Order ID 136061

Thursday, August 27, 2015 2:29:32 PM

136061

Page 3

Item ID: D3580-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Joggle Bracket

Start Date: 8/27/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/27/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
147	QC3- Inspect Part Finish	0.00				(20)			DAS 38 9-89
147									
QC	Memo	0.00							
Quality Control									SEP 15 2015
148	QC5- Inspect part completeness to step on W/O	0.00				(20)			DAS 38 9-89
148									
QC	Memo	0.00							
Quality Control									SEP 15 2015
150	Identify as per dwg & Stock Location: <u>st 043</u>	0.00				20			DAS 27 9-89
150									
Packaging	Memo	0.00							
Packaging									

SEP 15 2015

Thursday, August 27, 2015 2:29:32 PM

Item ID: D3580-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Joggle Bracket

Stop *NS2*

Start Date: 8/27/2015 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 8/27/2015 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.02

Quality Control

MC5

SEP 15 2115

MCS

SEP 15 2015

Picklist Print

Thursday, August 27, 2015 2:29:36 PM

Page 1

Work Order ID: 136061

136061

Parent Item: D3580-3

D3580-3

Parent Item Name: Joggle Bracket

Start Date: 8/27/2015

Required Date: 8/27/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.07.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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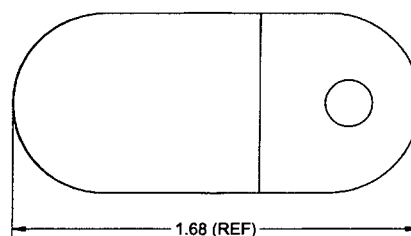
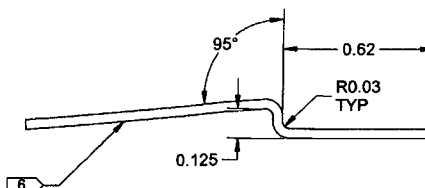
M304S18GA		Purchased		No			sf	238.1776		0.113684			
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M304S18GA

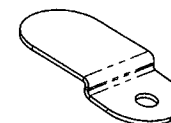
08/15/09/08

304/316 .050 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	151.1276	
M128254	4.1887	
M128435	25	
M128864	31.5964	
M129530	34.3667	
M130923	28.0424	
M131384	20.4334	
M132797	7.5	.2
MAT20	87.05	
M131700	87.05	



D3580-1 JOGGLE BRACKET



136061 MLS
150827

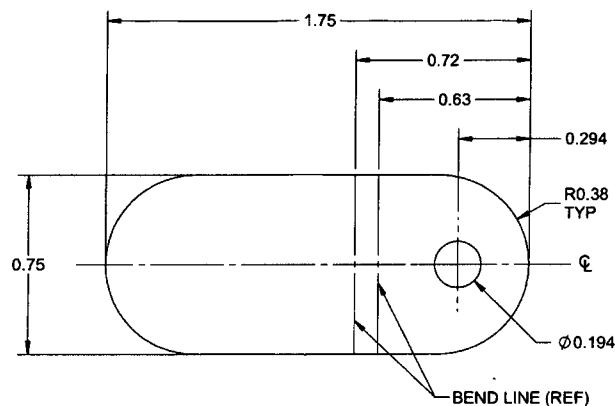
RELEASED
2014-07-02

- NOTES:**
- 1) MATERIAL: MADE FROM D3580-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
 - 7) WEIGHT: 0.01 lbs

C	UPDATED DWG FORMAT. ADDED D3580-3 (ZN B5-3) AND D3580-5 (ZN B5-4). ADDED SIDE VIEW TO D3580-1F (ZN D5-2)	AK	14.02.12
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3580 SHEET 1 OF 4 REV. C SCALE NTS JOGGLE BRACKET	
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS	JOGGLE BRACKET COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	DS		
DATE	14.02.12		

APPROVED

0.050 REF



D3580-1F FLAT PATTERN

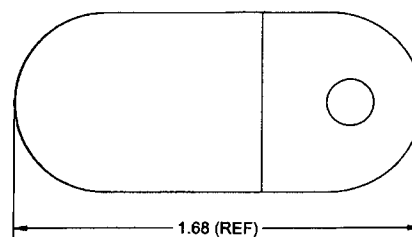
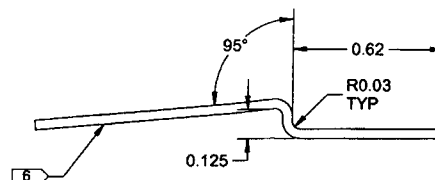
RELEASED
2014-07-02

NOTES:

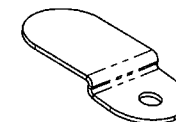
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
(REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	JOGGLE BRACKET	NTS
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D3580-3 JOGGLE BRACKET



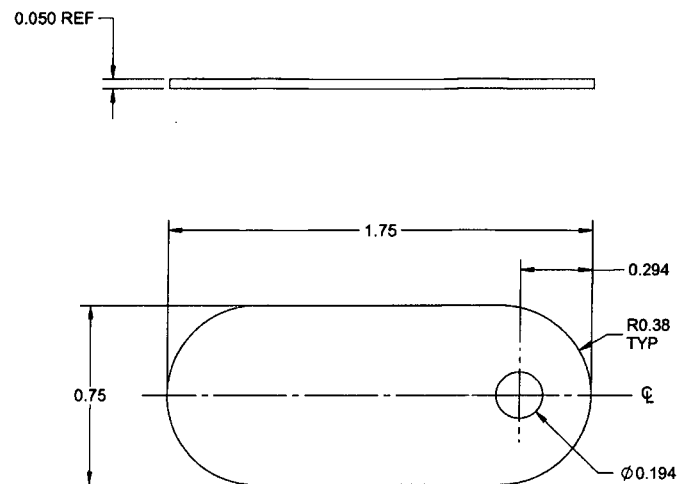
NOTES:

- 1) MATERIAL: MADE FROM D3580-1F
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 0.01 lbs

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DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
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D3580-5 BRACKET

NOTES:

- 1) MATERIAL: MADE FROM D3580-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

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DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AK	
CHECKED	VS	DRAWING NO. D3580 REV. C
MFG. APPR.	JLM	SHEET 4 OF 4
APPROVED	HS	TITLE JOGGLE BRACKET SCALE NTS
DE APPR.	DS	
DATE	14.02.12	

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